

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Tuesday, April 21, 2015 1:56:48 PM

Item ID: D5190-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Armrest Fitting

Start Date: 4/15/15 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 4/20/15 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

[illegible]

150

Identify as per dwg & Stock Location: W400 0.00

150

Packaging

Memo

0.00

DAS
6
9-89

Packaging

160

QC21- Final Inspection - Work Order Release	0.00
---	------

160

QC

Memo

0.00

Quality Control

APR 28 2015

MCS APR 29 2015

MLJ APR 29 2015

DQA: _____ Date: _____



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Picklist Print

Tuesday, April 21, 2015 1:56:47 PM

Page 1

Work Order ID: 131921

131921

Parent Item: D5190-1

D5190-1

Parent Item Name: Armrest Fitting

Start Date: 4/15/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.11.27 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR1.250		Purchased		No			f	6.2500		0.317474			

M4130NR1 250

215-4-27

4130N ROUND BAR 1.250

Location

Loc Qty

Loc Code

MAT033

6.25

111874

6.25

34

DQA: _____ Date: _____

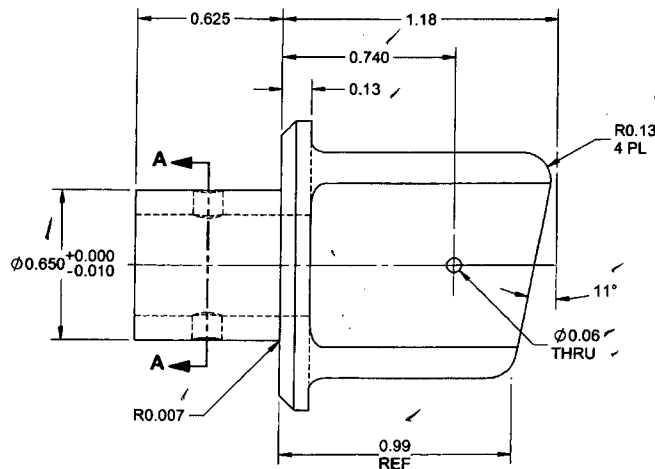
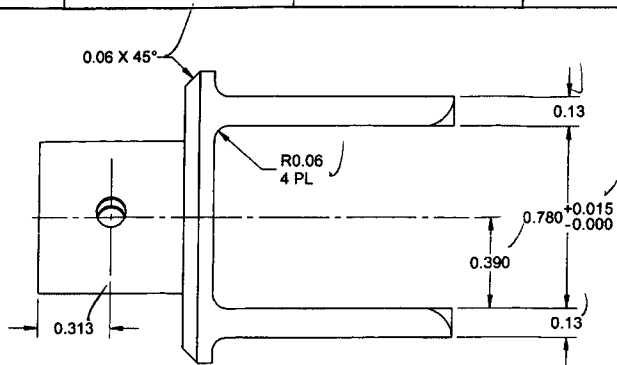


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Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER :																							



D5190-1 ARMREST FITTING

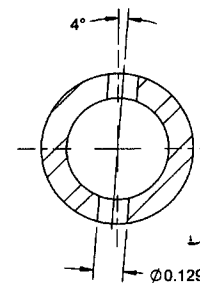
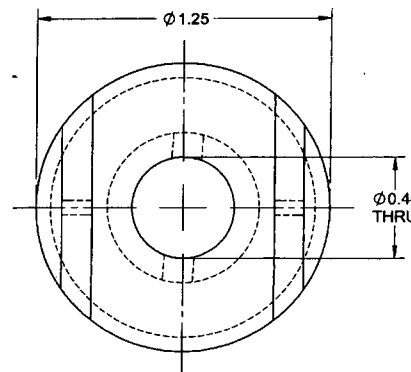
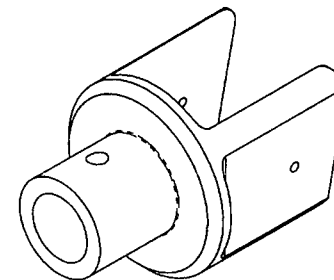
NOTES:

- 1) MATERIAL: AISI 4130N ROUND BAR
PER MIL-S-6758 OR AMS 6348/6370/6528
REF M4130N-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

STAMP COPY

STAMP COPY

131921 MLJ
150422



SECTION A-A

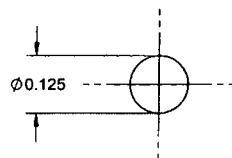
RELEASED

2015 FEB 04

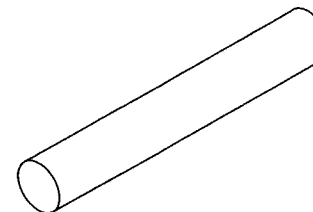
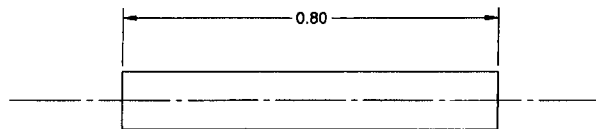
ZEN 15-522 90

APPROVED

A		NEW ISSUE		AJS	14.11.19
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED	AP	DRAWING NO.		REV. A	
MFG. APPR.	JLM	D5190		SHEET 1 OF 2	
APPROVED	HS	TITLE			SCALE
DE APPR.	DS	ARMREST MACHINED PARTS			NTS
DATE	14.11.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD			
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D5190-3 WELD PIN



NOTES:

- 1) MATERIAL: AISI 4130N ROUND BAR
PER MIL-S-6758 OR AMS 6348/6370/6528
REF M4130N-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: <0.01 lbs

RELEASED

2015 FEB 04

EN 15-522 4P

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5190	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARMREST MACHINED PARTS	
DATE	14.11.19	NTS	

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